



# Model: 641

Watts: 2500

Heat Stages: 30



## Output Voltages

Switch Position	<u>AB/Low</u>	<u>BC/Med</u>	<u>AC/High</u>
1	1.9	3.3	5.3
2	2.0	3.5	5.6
3	2.1	3.7	5.9
4	2.3	3.9	6.2
5	2.4	4.1	6.5
6	2.5	4.3	6.8
7	2.6	4.5	7.1
8	2.7	4.7	7.4
9	2.8	4.9	7.7
10	3.0	5.1	8.0

1. Choose one of three secondary circuits: AB/Low, BC/Medium, AC/High
  - It is recommended first using AB/Low—switch position '1'.
2. Fasten the electrode holder to either terminal of the selected circuit and the ground cord to the other terminal.
  - Double electrode holders do not require a ground cord.
3. Clamp the work piece with the ground clamp to complete the circuit.
  - Not necessary with double electrode holders.
  - It also possible to clamp or bolt the ground cord to a vise to ground the work piece while holding it.
4. Turn selector switch (and/or change secondary circuit) to gradually increase heat until desired result is achieved for the application.
  - For best performance keep the inside of electrode tubes clean with steel brush (part #'s: 775 & 785).

## To see our complete line of equipment:

- *Etching*
- *Soldering*
- *Demagnetizing*

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### Parts checklist:

- ((3) 3/8" Attachment Knob
- (1) Switch Knob

### Luma Electric Co.

3419 Silica Road  
Sylvania, Ohio 43560  
PH: 419-843-7842  
FAX: 419-843-7984

email: [info@lumaelectric.com](mailto:info@lumaelectric.com)  
website: [www.lumaelectricco.com](http://www.lumaelectricco.com)